

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021651**Date Inspected:** 22-Mar-2011**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Goodwin Steel, UK**OSM Arrival Time:** 800**OSM Departure Time:** 1730**Location:** Trentham, UK**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Cable Band**Summary of Items Observed:**

The following report is based on METS observations at Goodwin International, Trentham, UK on this date:

SHOP REVIEW:

The QA Inspector observed that Goodwin International personnel continue to perform verification of the quantities of cable band bolts, nuts and washers. It appears that there may be a discrepancy between the number of items reported on the Certificate of Conformance from BST, and the actual quantities received

The QA Inspector did observe that casting GG29441-2 excavations 31 and 32 are being subjected to localized post weld heat treatment. The temperature was held at 630 +/- 20 degrees for four hours. The post weld heat treatment appeared to conform to project requirements.

QA Inspector observed welding of Casting GG29425-2, Drawing Number 5540-B5-1-F for east panel point 66. The welding was being performed by Mr. Dan McDonagh. Mr. McDonagh was using WPS04-102F4B Issue 5. The welding was being preformed at 161 amps. The filler metal was 4mm AWS A5.1, E7018-1. Welding was being performed in the 1G position.

The QA Inspector observed the cable band for East Panel Point 6, consisting of castings GG29450-2, 5540-B16-1-M and GG29451-2, 5540-B16-1-F at the CMM for dimensional verification. Mr. A. Cashmore has marked and area approximately 25% of the surface area of one casting for weld repair due to insufficient wall thickness, and a small area on the mating casting also with insufficient wall thickness.

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The QA inspector periodically observed that Goodwin International personnel perform finish grinding of a B8 Type 1 cable band for west panel point 22 (WPP-22), casting 5540-B8-1-M-8 and casting 5540-B8-1-F-1. The rope grooves are being ground to finish condition. A B11 Type 2 cable band casting 5540-B11-2-M-2, Weld map GG29442-2(R1) excavation 21 is being dressed to required dimensions and finish by Goodwin International personnel.

Summary of Conversations:

Relevant conversations are documented above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
